

Work Order ID 72172

Tuesday, July 19, 2011 1:52:50 PM



Page 1

Item ID: K10003

Accept



Setup Start



Revision ID:

Item Name: Saddle, D205-634-011

Stop



Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 008

CHG 007

5/11/05/07

11/8/5 (4)

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

11/8/5 (4)

120

0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

8/11/05/122

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72172

Tuesday, July 19, 2011 1:52:50 PM



Page 2

Item ID: K10003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, D205-634-011

Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

0.00

Memo

Rev 1

pk

11/8/22

f

42

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/8/23

MF
11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, July 19, 2011 1:52:57 PM

Page 1

Work Order ID: 72172

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O
 11.03.11 per dsi9536 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-51A Bolt		Purchased	No			110	Each	131.0000	8	32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST361				131					
				117094				81		32			
				117514				50					
AN4-6A Bolt		Purchased	No			110	Each	762.0000	16	64			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				562		64			
				116924				362					
				117872				200					
				ST358				200					
				117514				200					
AN4C46A BOLT		Purchased	No			110	Each	145.0000	4	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST360				145		16			
				110823				145					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Tuesday, July 19, 2011 1:52:57 PM

Page 2

Work Order ID: 72172

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

S ₄	AN6-12A	Purchased	No	110	Each	65.0000	8	32	11/8/8
	Bolt								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST342	65			19	
				117094	55			13	
				118112	10				
S ₄	AN960JD416	Purchased	No	110	Each	0.0000	32	128	11/8/79
	Washer								
S ₄	AN960JD616	Purchased	No	110	Each	0.0000	8	32	11/8/318
	Washer								
S ₄	D2570	Manufactured	No	110	Each	253.0000	24	96	SL
	Bushing								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST017	253				
				66933	1				
				67759	6				
				70971	82				
				71832	164				
S ₄	D2571	Manufactured	No	110	Each	0.0000	1	4	B71360
	Saddle, Fwd Out 205								
S ₄	D2572	Manufactured	No	110	Each	0.0000	1	4	B7231
	Saddle, Fwd In 205								
S ₄	D2573	Manufactured	No	110	Each	0.0000	1	4	B71373
	Saddle, Aft Out 205								

Tuesday, July 19, 2011 1:52:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, July 19, 2011 1:52:57 PM

Page 3

Work Order ID: 72172

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

D2574

Manufactured No

3

110 Each

0.0000

1

Saddle, Aft In 205

D2747

Manufactured No

110 Each

138.0000

4

Set Screw

Location

Loc Qty

Loc Code

ST021

138

69494

38

71163

100

D2876

Manufactured No

110 Each

35.0000

2

Saddle Spacer

Location

Loc Qty

Loc Code

ST025

29

70767

29

ST026

6

68282

6

D2877

Manufactured No

110 Each

25.0000

2

Saddle Spacer

Location

Loc Qty

Loc Code

ST025

25

68283

25

D3405-041

Manufactured No

110 Each

3.0000

1

Lug Assembly

Location

Loc Qty

Loc Code

ST474

3

62227

2

70820

1

Tuesday, July 19, 2011 1:52:58 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Tuesday, July 19, 2011 1:52:58 PM

Page 4

Work Order ID: 72172

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

D3405-043

Manufactured No

110 Each

2.0000

1 4



Lug Assembly



B708215

Location

Loc Qty

Loc Code

ST423

2

65703

2

D3407-041

Manufactured No

110 Each

0.0000

1 4



Tow Ring



2x B68 071 B72145

D3417-5

Manufactured No

110 Each

58.0000

2 8



Washer



Location

Loc Qty

Loc Code

ST053

58

68972

17

71855

41

D3456-1

Manufactured No

110 Each

82.0000

1 4



Washer



5/3 11/8/5

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

75

66848

3

71033

22

71165

50

7

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Tuesday, July 19, 2011 1:52:58 PM

Page 5

Work Order ID: 72172

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

D3533-1

Manufactured No

110 Each

40.0000

2



Set Screw

Location

Loc Qty

Loc Code

ST066

40

67583

40

MS21042L4

Purchased No

110 Each

3,764.000

24



Nut

Location

Loc Qty

Loc Code

ST300

3764

117441

1517

117601

747

117885

1500

MS21043-4

Purchased No

110 Each

627.0000

5



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

587

117601

87

117793

500

Tuesday, July 19, 2011 1:52:58 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	*WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F AND
INSTALLATION INSTRUCTIONS D204-635 REV. F

REF. TCCA STC SH96-88

REF. FAA STC SR00563NY

REF. EASA STC EASA.IM.R.S.01303

REFERENCE ONLY

PURPOSE:

THE PARTS LIST OF INSTALLATION INSTRUCTIONS D205-634 REV. F AND D204-635 REV. F LISTS THE INCORRECT PART NUMBER FOR THE BOLT PROVIDED WITH D205-641-011 GROUND HANDLING KIT. THE CORRECT PART NUMBER FOR THE BOLT IS AN4C46A.

CHANGE:

THE PART NUMBER IN SECTION 5.0 OF D205-634 REV. F AND D204-635 REV. F AND SECTION 32.9 OF ICA-D204-635 REV. 3 IS AMENDED AS FOLLOWS:

5.0 PARTS LIST (D205-634 REV. F)

Item	634 -011	634 -015	634 -041	634 -045	641 -011	PART NUMBER	DESCRIPTION
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
1			X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
1	1				X	D205-641-011	GROUND HANDLING KIT

IS:

52					4	AN4C46A	BOLT
----	--	--	--	--	---	---------	------

WAS:

52					4	AN4C47A	BOLT
----	--	--	--	--	---	---------	------

5.0 PARTS LIST (D204-635 REV. F)

32.9 PARTS LIST (ICA-D204-635 REV. 3)

Item	635 -011	635 -041	641 -011	PART NUMBER	DESCRIPTION
	X			D204-635-011	SKIDTUBE INSTALLATION
1		X		D204-635-041	SKIDTUBE
1			X	D205-641-011	GROUND HANDLING KIT

IS:

52			4	AN4C46A	BOLT
----	--	--	---	---------	------

WAS:

52			4	AN4C47A	BOLT
----	--	--	---	---------	------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.11.26

CERT. NO.: SH96-88

ISSUE NO.: 3

A	NEW ISSUE (REF. CAR10-27)	MB	10.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9536	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		P/N CORRECTION	NTS
DATE	10.11.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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